



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D3825-043
Job Sheet 192460



Part No: D3825-043

Job Qty: 4 pcs

Part Name: Rib Assembly (Basket End, Lid)



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 3/26/19

Job Tracking No:

Due Date: 4/12/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV C IPP REV:A 12.07.24 AS PER REV.B DD VERF:EC IPP REV:B 12.08.08 AS PER DWG REV.C DD VERF:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Large Fab - Basket - 1	4 pcs	4/12/19	4/12/19	0.00	4.44	Large Fab - 1		
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		
130	QC 9	4 pcs	4/12/19	4/12/19	0.00	0.00	Large Fab - 9		
							QC 9 - 10		
							QC 9 - 18		
							QC 9 - 43		
							QC 9 - 50		
							QC 9 - 9		
140	QC 5	4 pcs	4/12/19	4/12/19	0.00	0.00	QC 9 - 10		
							QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		

Plex 3/26/19 9:06 AM Dart.lajeunesse.marie

150 Packaging 3-1 - Stock - B4B 4 pcs	4/12/19	0.00 0.00	QC 5 - 50	
			QC 5 - 30	
			QC 5 - 40	
			Packaging 3 - 1 - B4B	
			Packaging 3 - 2 - B4B	
			Packaging 3 - 3 - B4B	
			Packaging 3 - 4 - B4B	
			Packaging 3 - 5 - B4B	
			Packaging 3 - 6 - B4B	
			Packaging 3 - 7 - B4B	
			Packaging 3 - 8 - B4B	
			Packaging 3 - 9 - B4B	
			Packaging 3 - 10 - B4B	
			Packaging 3 - 11 - B4B	
			Packaging 3 - 12 - B4B	
			Packaging 3 - 13 - B4B	
			Packaging 3 - 14 - B4B	MAR 27 2019
			Packaging 3 - 15 - B4B	
			Packaging 3 - 16 - B4B	
			Packaging 3 - 17 - B4B	DAS
			Packaging 3 - 18 - B4B	24
			Packaging 3 - 19 - B4B	9-89
			Packaging 3 - 20 - B4B	
			Packaging 3 - 21 - B4B	
			Packaging 3 - 22 - B4B	
			Packaging 3 - 23 - B4B	
			Packaging 3 - 24 - B4B	
			Packaging 3 - 25 - B4B	
			Packaging 3 - 26 - B4B	
			Packaging 3 - 27 - B4B	
			Packaging 3 - 28 - B4B	
			Packaging 3 - 29 - B4B	
			Packaging 3 - 30 - B4B	
			Packaging 3 - 31 - B4B	
			Packaging 3 - 32 - B4B	
			Packaging 3 - 33 - B4B	
			Packaging 3 - 34 - B4B	
			Packaging 3 - 35 - B4B	
			Packaging 3 - 36 - B4B	
160 QC 21 - SA 4 pcs	4/12/19	0.00 0.00	QC 21 - SA - 21	DAS
			QC 21 - SA - 70	21
			QC 21 - SA - 53	9-89

Part Op 100 - Fabricate per Drwg 1- cut D3825-3 rib as per dwg D3825 2- drill hole (3/16") in D3825-3 using DT9822 jig and open Descriptions: to finish size as per dwg D3825 6- weld D2327-1 spacer & D4021-9 bushing as per dwg D3825

130 - QC9- Inspect visual per QSI004- Fusion Welds

140 - QC5- Inspect part completeness to step on W/O

150 - Identify as per dwg & Stock Location: LOCATION WA004-7

160 - QC21- Final Inspection - Work Order Release --1- assemble D2325 support gusset together 2- locate D2325 on rib and weld as per dwg D3826 A/R ER316 S.S. Rod Batch: 138840

#

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2327-1	Spacer Bushing	4 pcs (1 ea)	100-Large Fab - Basket - 1	5104170
D4021-9	Bushing	8 pcs (2 ea)	100-Large Fab - Basket - 1	5115312
M304TS0.750W.065	304 Sq Tube .75X.75X.065W	8.5000 ft (2.125 ea)	100-Large Fab - Basket - 1	5155739

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Large Fab - Basket - 1	D2327-1	4	23	0
	D4021-9	8	162	0
	M304TS0.750W.065	9	619	0
Part Specifications				
Specifications could not be found.				

Plex 3/26/19 9:06 AM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA
TEL.: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S166726



Part: D3825-043

Job No: 192460

Serial No/Batch: S166726

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 03/27/19